



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2600-3-BENT-RH
Job Sheet 171362



Part No: D2600-3-BENT-RH

Job Qty: 6 ea

Part Name: Extrusion Bent RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/31/18

Job Tracking No:

Due Date: 2/9/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D2750 REV G SHEET 4, D2600 REV E SHEET 2 IPP REV:A 14.01.14 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		2/8/18	0.00	0.00	Start Up Skidtubes-3		3/2/18
100	CNC Bend Skidtubes	6 pcs		2/9/18	0.23	2.99	CNC Bend Skidtube		Marie Lajeunesse
110	QC	6 pcs		2/9/18	0.00	0.00	QC5		BE
120	Packaging	6 pcs		2/9/18	0.00	0.00	Packaging3-1		
130	QC21-SA	6 Ea		2/9/18	0.00	0.00	QC21		

Part Op 100 - Pick qty 1 D2600-3-130 extrusion 1-Deburr one end of extrusion 2-Bend using CNC bending machine as per:
Descriptions: program 2750.C and Folio 14 use bending aid DT9635 3- cut fwd end of tube as per dwg D2750 4- cut aft end of tube as per dwg D2750
120 - LOCATION :LG002

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2600-3-130	Extrusion Round 3" 350	6 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation B 162497	D2600-3-130	6	64	0

Part Specifications

Specifications could not be found.

Plex 1/31/18 11:04 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No _____	DISPOSITION Rework ☐ Scrap ☐ Skid-tube ☐ Machining ☐ Thermoforming ☐	AGAINST DEPARTMENT/PROCESS Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date _____ _____ _____	DART AEROSPACE Container No: S043928 Part: D2600-3-BENT-RH Job No: 171362 Serial No/Batch: S043928 Revision: D2750, D2600 Inspector: _____ Date: 02/20/18 DART AEROSPACE 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com				
		Disposition _____ _____ _____		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
ULT CATEGORY					
Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

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ENGINEERING

UNCONTROLLED COPY

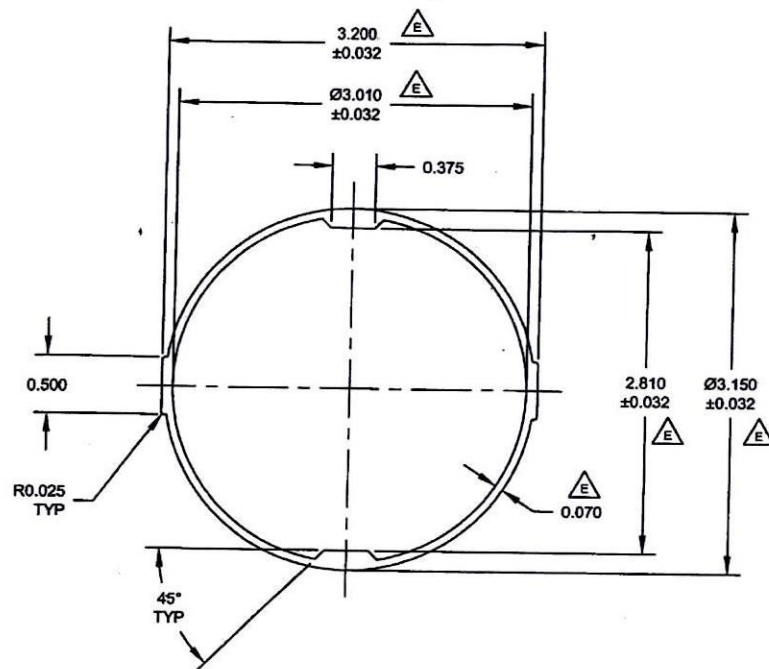
2 SUBJECT TO AMENDMENT

WITHOUT NOTICE

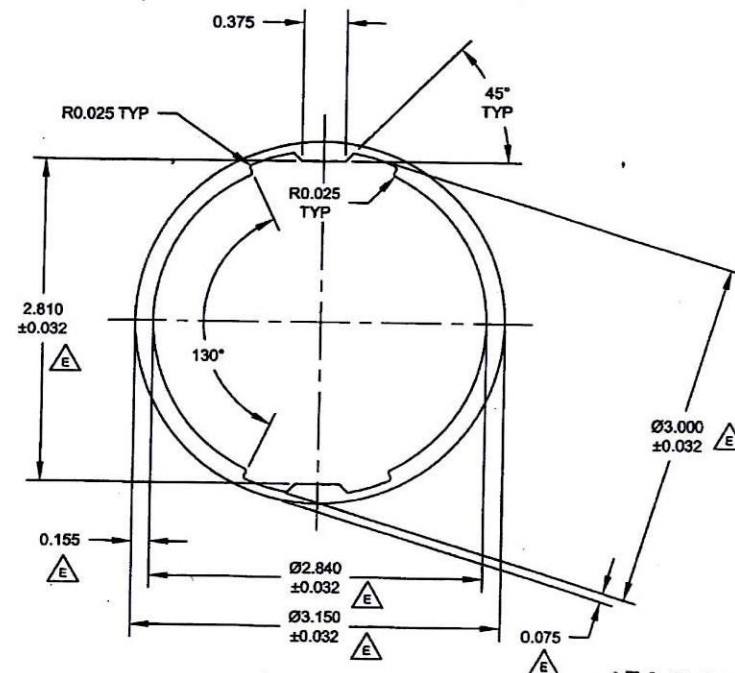
WORK ORDER

NO. 171263

JAN 30 2016



D2600-1 EXTRUSION

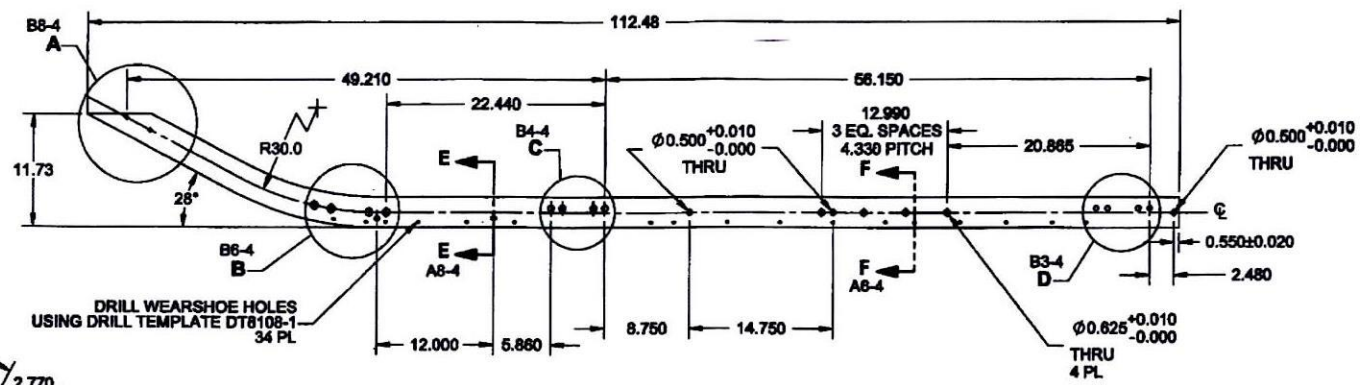


D2600-3 EXTRUSION

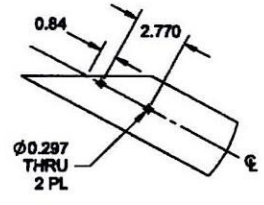
RELEASED
2012-01-11

DESIGN	4	DART AEROSPACE LTD	
DRAWN	JP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. E
MFG. APPR.	ES	D2600	SHEET 2 OF 3
APPROVED	WAP	TITLE	SCALE
DE APPR.	#	EXTRUSION	NTS
DATE	11.10.18	COPYRIGHT © 1987 BY DART AEROSPACE LTD	
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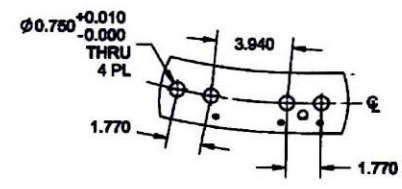
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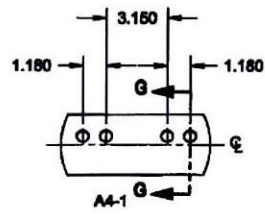
D2750-1 LH SKIDTUBE



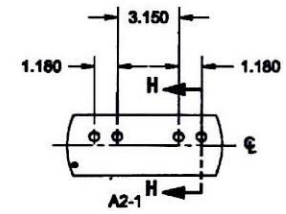
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SCALE 2X



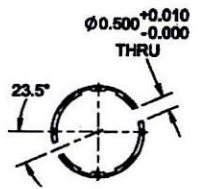
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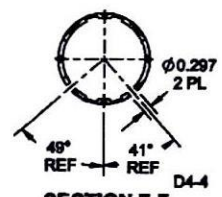
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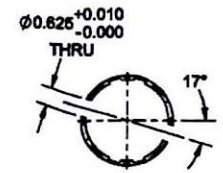
DETAIL D
SCALE 2X



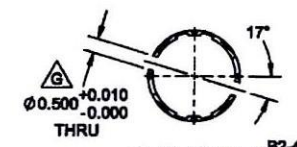
SECTION E-E
SCALE 3X, 2 PL



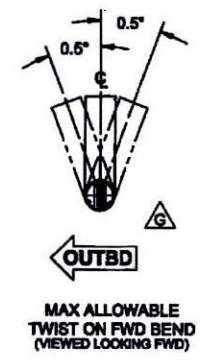
SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL



SECTION H-H
SCALE 3X, 4 PL



MAX ALLOWABLE TWIST ON FWD BEND (VIEWED LOOKING FWD)

RELEASED
2013-08-13
JAP

DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2750	SHEET 4 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	13.07.11	COPYRIGHT © 1988 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE BASIS OF THE GOVERNMENT CONTRACT IT IS PART OF THE GOVERNMENT PROPERTY AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM.	

8 7 6 5 4 3 2 1

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☒ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : 10/3/2		Step #:		QTY Effective :		MRB (QSI042) Approval DAS 12 10/3/2 9-89	
Description Work Order Deviation				Disposition			
Fwd bend is 29°.				Acceptable. Will not cause fit issue with step based on layout by CP			
				Completed By DAS 12 10/3/2 9-89			
				Lead hand / Supervisor Approval Verification 18-03-02			
				QC / QA Coordinator Approval			

Root Cause				FAULT CATEGORY			
Environment	☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure
Design	☐	☐	Operator	☒	Bending	☐	Set-up
Doc/Data	☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route
Equip/Tooling	☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect
Handling/Pre	☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified
Material	☒	☐	Use for Testing	☐	Cuffs	☐	Contamination
Internal Transport	☐	☐	Poor Information	☐	Crushing	☐	Countersink
Tribal Knowledge	☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short
LOA	☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear
Substation	☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes
Past Expiry Date	☐	☐	Manufacturing Process	☐			
Misidentified	☐	☐	Past Due	☐	OTHER :		